

Date: Wednesday, 11/16/2005 1:06:26 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 24209		Part Number	: D33191		
Estimate Number	: 10437		Drawing Number	: D3319 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/16/2005 S.O. No. : N/A		Drawing Revision	: B		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 11/23/2005 Qty: 1 Um: Each		
Previous Run	: 23340					
Written By	: See comment below					
Checked & Approved By	: See comment below					
Comment	: Est: B 05.10.14 Added step 9, dwg rev B		KJ/EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
<b>Comment:</b> PURCHASING Issue P/O: 2008540 Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3319 Possible Supplier: Industrial Laser Material release note is required		
2.0	D33191F	Wearplate
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARPLATE		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK
<b>Comment:</b> DIMENSIONAL CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary		

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Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: A

2- Form flat on press using DT8776 block

SP 05/12/06

7.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch  
A/R N/A 7560 Hardcoat Rod M19172 Cal 05.02.06

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

VISUAL WELDING INSPECTION

Cal 05/12/07

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 05 12 20

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ML 05/12/21

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 88

Co 06/01/07

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13.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21

5AC 06/01/05



①

① 06/01/05

Job Completion



## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyNov 08, 2005  
11:10 am

Work Order No : 0024209  
 Project Name : D3319-1  
 Project For : WK537  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3319-1  
 Description : Wearplate  
 Manufactured : Yes  
 Amount Req'd : 4  
 Amount Done : 2  
 Start Date : 09-02-05  
 Est Finish Date : 09-12-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 CVO81

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%

Part/All Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	25.76	100.00	25.76	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	8.42	100.00		
Production Cost :	0.00	152.75	100.00	55.36	97.39
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	178.51	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	178.51			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	4.21
Profits/ (Loss) :	0.00	( -178.51)